

Date: Monday, 9/10/2007 1:19:02 PM
User: Kim Johnston

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 34476 -1	Part Number	: D3560043
Estimate Number	: 12883	Drawing Number	: D3560 UNDER REVIEW
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 9/10/2007 S.O. No. : N/A	Drawing Revision	: 86
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Due Date	: 9/17/2007
Previous Run	: 32646	Qty:	5.12 Um: Each
Written By	: [Signature]		
Checked & Approved By	: [Signature]		
Comment	: Est Rev:A New Issue 07.05.24 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"
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Comment: Qty.: 1.3598 f(s)/Unit Total : 16.3170 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: M1051046

mk 07/09/20 (5) 12

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks 15.500" long

mk 07/09/20 (5) 12

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA695 Rev: AA & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

2507/09/22

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2507/09/22

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 07/09/23

Date: Monday, 9/10/2007 1:19:02 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34476

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

PLATE 3 34260

12-07-10-10

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

12-07-10-10

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/10

AD 07-10-10

(15)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-10-10

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M 07-10-10

(15)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WFA

Q.M 07-10-11

(15)

Date: Monday, 9/10/2007 1:19:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34476

Part Number: D3560043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

D 09/10/12

Job Completion



U 09-10-12

1877

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DART AEROSPACE LTD		Work Order:	34476
Description: Arm		Part Number:	D3560-3
Inspection Dwg: D3560	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

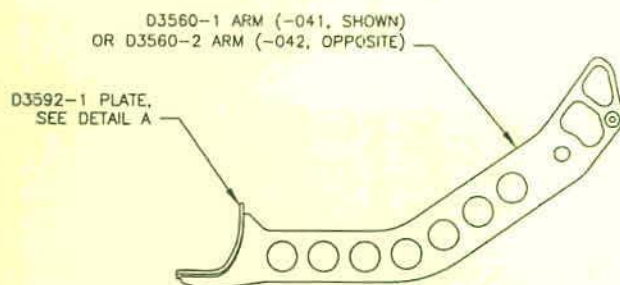
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.5065	✓			
Ø0.196	+0.005/-0.001	.197	✓			
Ø1.000	+0.010/-0.001	1.004	✓			
Ø0.900	+0.010/-0.001	.999	✓			
0.500	+/-0.010	.495	✓			
0.250	+/-0.010	.250	✓			
0.275	+/-0.010	.274	✓			
0.188	+/-0.010	.193	✓			
2.000	+/-0.010	.2001	✓			
1.750	+/-0.010	1.750	✓			
1.702	+/-0.010	1.705	✓			
Ø0.385 x 100°	+/-0.010 x 0.5°	.380 x 100°	✓			
0.250 Deep	+/-0.010	.253	✓			

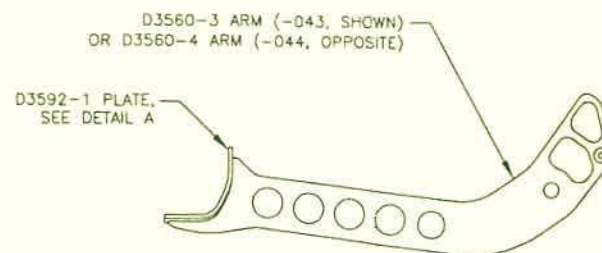
Measured by:	J.L.B.A.	Audited by:	36	Prototype Approval:	N/A
Date:	07/09/21	Date:	07-09-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	E

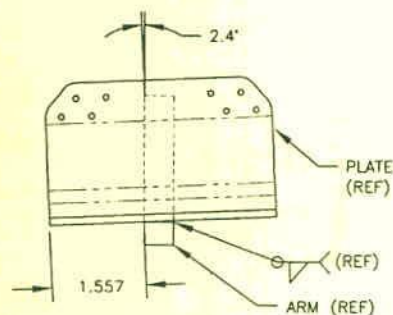
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D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
(07.06.19)

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C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3560
DATE		TITLE ARM WELDMENT
07.06.19		SCALE 1:4

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WORK ORDER
34476

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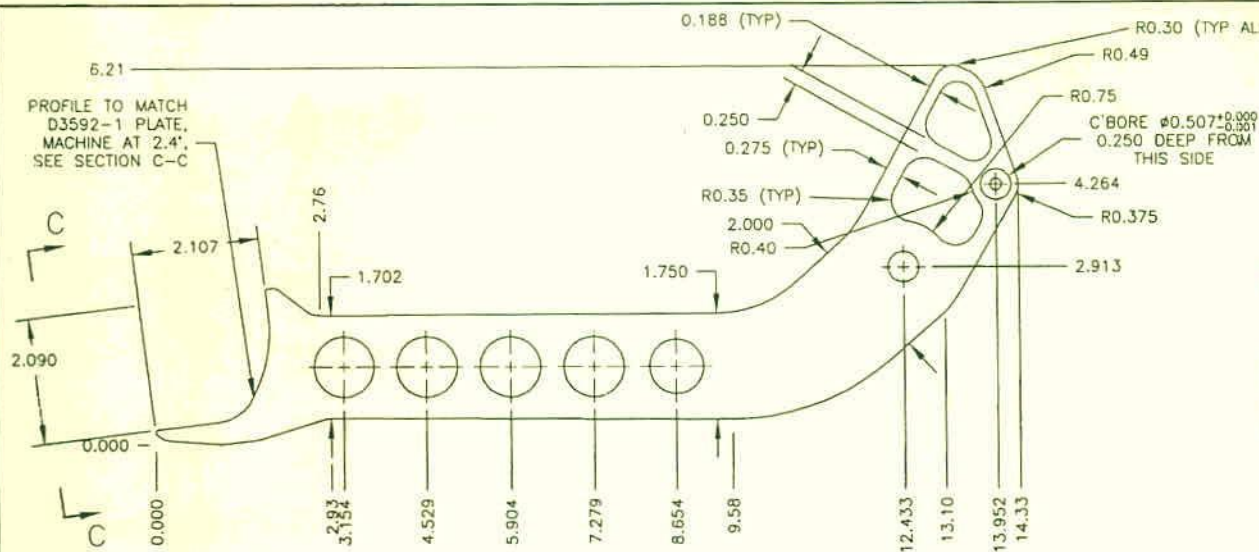
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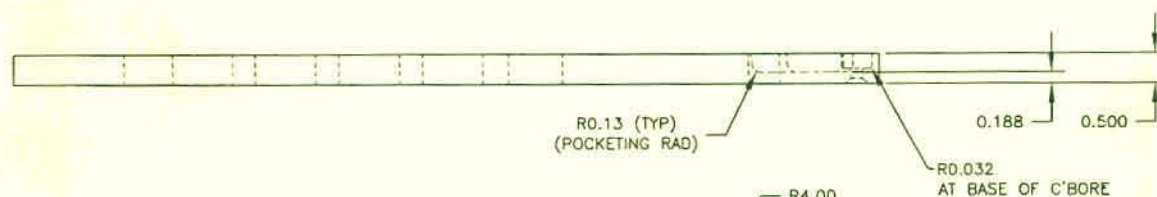
DESIGN	DRAWN BY		DART AEROSPACE LTD. MIDLAND, ONTARIO, CANADA
GP	GP		
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3560	SHEET 2 OF 2
DATE	TITLE		SCALE
07.06.19	ARM WELDMENT		1:1

PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4'
SEE SECTION C-C

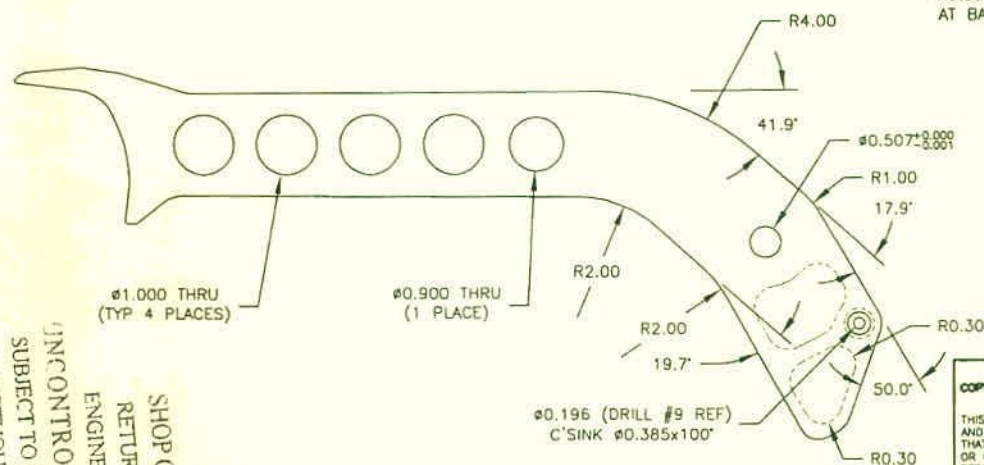


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



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07.06.19

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DESIGN	q	DRAWN BY	q	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	h	APPROVED	h	DRAWING NO. D3560	REV.
DATE	07.06.19	TITLE	ARM WELDMENT	SHEET 3 OF	SCA

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